

Abstract

Abstract

Item Name: Plug

[illegible]**Cust Item ID:**

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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Customer:

Reference:

Date:



Date:

[illegible]

**Insp.
Stamp**

Revision Nbr

Rev B

0.00

Hardinge CNC LATHE SMALL

Memo

0.00

1- Turn as per Folio FA219 and Dwg D2651 □ 2- Deburr

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

Work Order ID 53349

November 2, 2009 10:41:47 AM



Page 2

Item ID: D2651-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Plug

Start Date: 02/11/2009 Start Qty: 440.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 440.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr ias per dwg D2651								
140		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
145		0.00							
	Spray Painting per QSI005 4.2								
SprayPaint	Memo	0.00							
Spray Painting	Prime B 110918								
	Spray Paint Delfleet Blue B 110077								
	Clear Delfleet B 113053								

Work Order ID 53349

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Item ID: D2651-1

Accept

Revision ID: B

Item Name: Plug

Start Date: 02/11/2009 Start Qty: 440.00

Required Date: 13/11/2009 Req'd Qty: 440.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

155

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

443
QSPOR

05-11-12

170

Identify as per dwg & Stock Location: *FRA* 0.00

Packaging

Memo

0.00

Packaging

BR 09-11-12 443.

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/11/13
MF 09-11-12

Picklist Print

November 2, 2009 10:41:53 AM

Page 1

Work Order ID: 53349

Parent Item: D2651-1RevB

Parent Item Name: Plug

Comments:

Start Date: 02/11/2009

Required Date: 13/11/2009

Start Qty: 440.00

Required Qty: 440.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6R0.500

Purchased

No

100

f

50.6070

18.5726



6061-T6 Round Bar .500"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

50.607

110532

36

111448

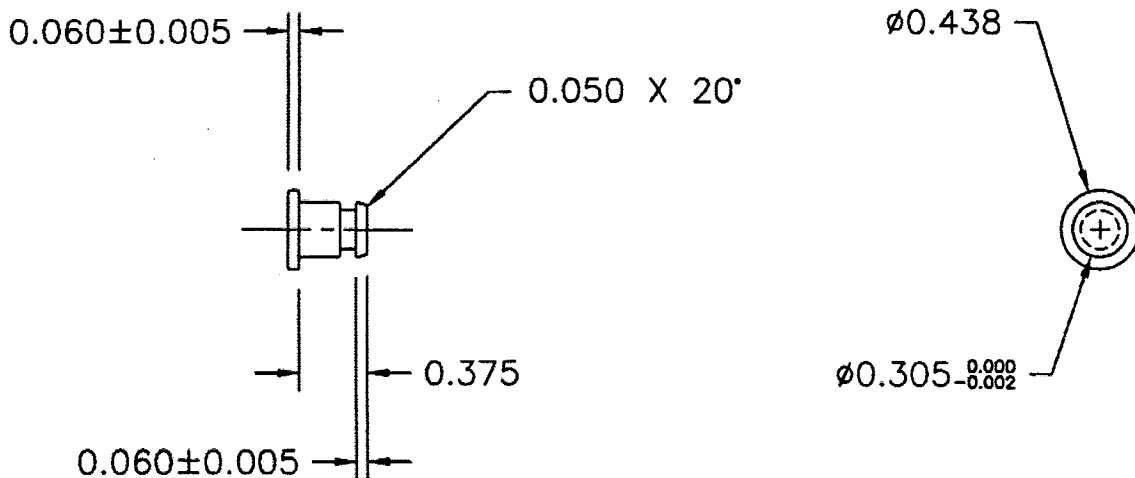
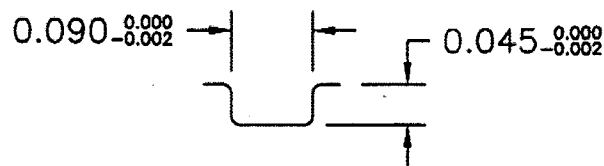
14.607

251027

12 PF SA 08/11/04
10 PF SA 08/11/04

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED03.12.19 *[Signature]***D2651-1 PLUG:****GROOVE DETAIL (SCALE 5:1)**

FOR COPY
FOR TO
FOR WORKING
FOR CONTROLLED COPY
FOR TO AMENDMENT
FOR NOTICE
WORK ORDER
NO. 53349
BA 09-11-2

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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